

Work Order ID 62492

Thursday, September 30, 2010 2:31:19 PM



Page 1

Item ID: D3909-5

Accept



Setup Start



Revision ID:

Item Name: Eyebolt Stud

Stop



Start Date: 9/30/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 10/8/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10-9-30

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3909	C								

100



Doosan

Doosan Lathe

Memo

turn as per dwg and folio FA872

DWG REV: C

FOLIO REV: AA

0.00

10.11.3

8

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

10.11.3

8

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC8- Inspect parts - second check

0.00

G.A 10/11/04

8

QC

Memo

0.00

Quality Control

150



Identify as per dwg & Stock Location: 694

0.00



Packaging

Memo

0.00

Packaging

160



QC21- Final Inspection - Work Order Release

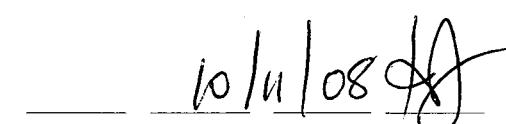
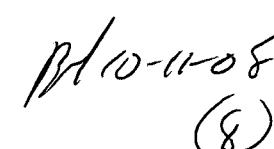
0.00

QC

Memo

0.00

Quality Control

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Picklist Print

Page 1

Thursday, September 30, 2010 2:31:23 PM

Work Order ID: 62492



Parent Item: D3909-5



Parent Item Name: Eyebolt Stud

Start Date: 9/30/2010

Required Date: 10/8/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD IPP Rev:B
as per dwg revB DD 10.04.20 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R1.000 		Purchased	No			100	f	28.0560	0.25	2.106263 <i>00 10. 01 - 3</i>			

303 Round Bar 1.00

Location	Loc Qty	Loc Code
MAT	24 115774 ✓	 2-537
MAT028	4.056	<hr/> <hr/>
	4.056	
113325		

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	621492
Description: Eyebolt Stud	C 4 mm 10-11-05	Part Number:	D3909-5
Inspection Dwg: D3909	Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Preliminary Approval:	
Date:	10-11-03	Date:	10/11/04	Date:	

Rev	Date	Change	Revised by	Approved
A	10.04.20	New Issue	KJ	 

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

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5

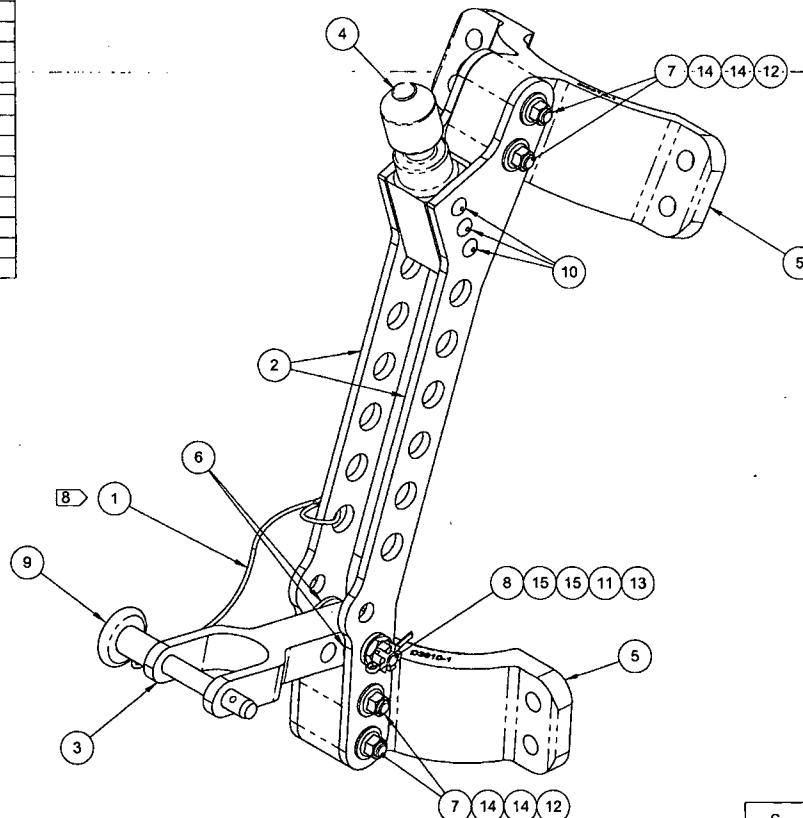
4

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1

ITEM	QTY	P/N	DESCRIPTION
	X	D3909-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	2	D3909-1	FWD X-TUBE LUG PLATE
3	1	D3909-3	FWD LOWER ATTACH ARM
4	1	D3909-5	EYEBOLT STUD
5	2	D3910-1	X-TUBE LUG
6	2	D3917-1	WASHER
7	4	AN3C12A	BOLT
8	1	AN3C13	BOLT
9	1	MS17984-C413	PIP PIN
10	3	MS20615-4M20	RIVET
11	1	AN310C3	NUT - CASTELLATED
12	4	MS21043-3	NUT
13	1	MS24665-151	COTTER PIN
14	8	NAS1149C0332R	WASHER
15	2	NAS1149C0363R	WASHER



D3909-041 FWD X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.81 lbs
- 8) ATTACH D2690-6 TO D3909-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *62492*
BS10-9-30

RELEASED
2010-08-04
MD

C	ITEM #4: 1.50 WAS 1.30 (ZN B5-5), 2.88 WAS 2.68 (ZN B6-5); WEIGHT AFFECTED (D3909-041-5).	MB	10.06.18
B	BOM: ADDED ITEM 15 QTY 2 NAS1149C0363R ADDED, ITEM 14 QTY 8 WAS 10. SHT 5. D3909-5 REVISED; SECTION A-A & DIM Ø0.650 REMOVED. SIDE VIEW ADDED. DIM: 2.68 WAS 2.38 REF. 1.30 WAS 1.00, 0.250 WAS 0.220, R0.05 WAS R0.05. WEIGHT REVISED.	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>13</i>		
CHECKED	<i>10</i>		
MFG. APPR.	<i>SD</i>	DRAWING NO. D3909 REV. C	
APPROVED	<i>KW</i>	SHEET 1 OF 5	
DE APPR.	<i>MM</i>	TITLE FWD X-TUBE LUG ASSY NTS	
DATE	10.06.18	SCALE	

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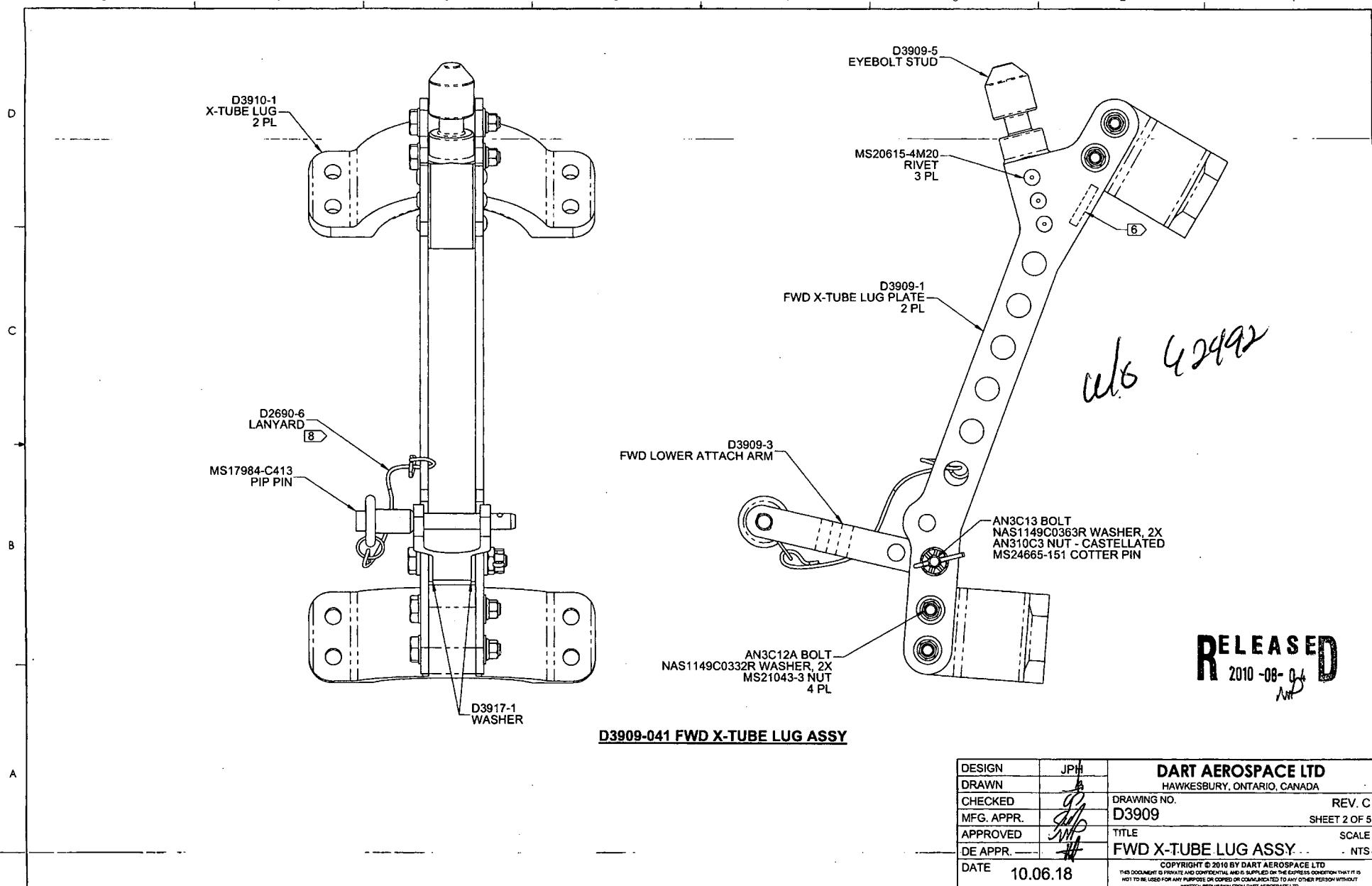
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

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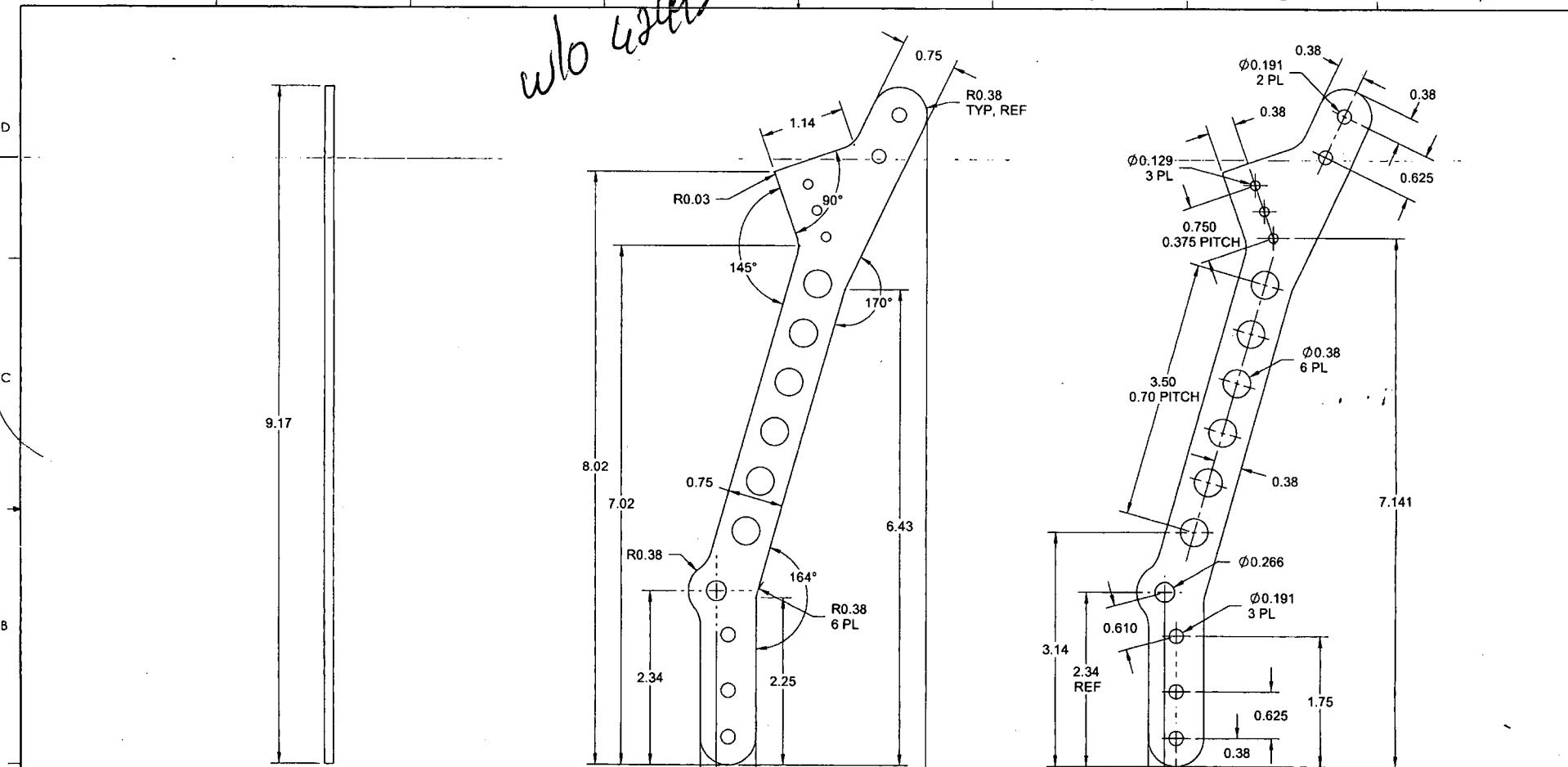
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wb 4/2012



D3909-1 FWD X-TUBE LUG PLATE

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" THICK SHEET ANNEALED 2B, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M303S11GA OR M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.25 lbs

(SUPPLEMENTAL VIEW)

RELEASED
2010-08-06
[Signature]

DESIGN	JPH	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	REV. C
MFG. APPR.	<i>[Signature]</i>	DRAWING NO. D3909
APPROVED	<i>[Signature]</i>	SHEET 3 OF 5
DE APPR.	<i>[Signature]</i>	TITLE FWD X-TUBE LUG ASSY
DATE	10.06.18	SCALE NTS

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A

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

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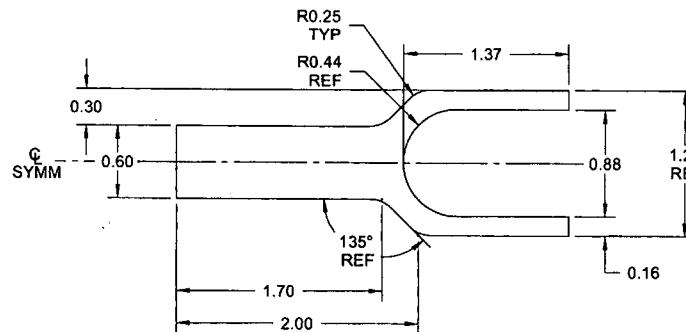
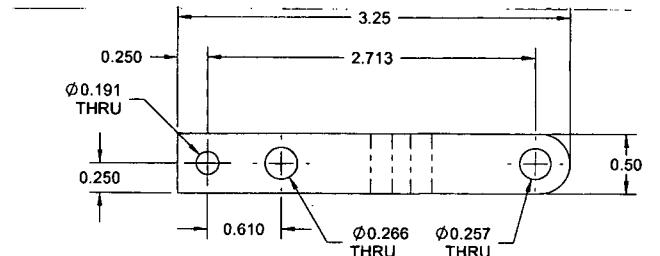
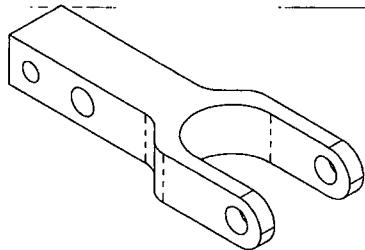
C

B

B

A

A



D3909-3 FWD LOWER ATTACH ARM

RELEASED
2010-08-01
[Handwritten signature]

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A582 OR ASTM A276
PER DART SPEC M303B OR M304B
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.22 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D3909	
MFG. APPR.	<i>[Signature]</i>	REV. C	
APPROVED	<i>[Signature]</i>	SHEET 4 OF 5	
DE APPR.	<i>[Signature]</i>	TITLE FWD X-TUBE LUG ASSY	
DATE	10.06.18	SCALE NTS	

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8 7 6 5 4 3 2 1

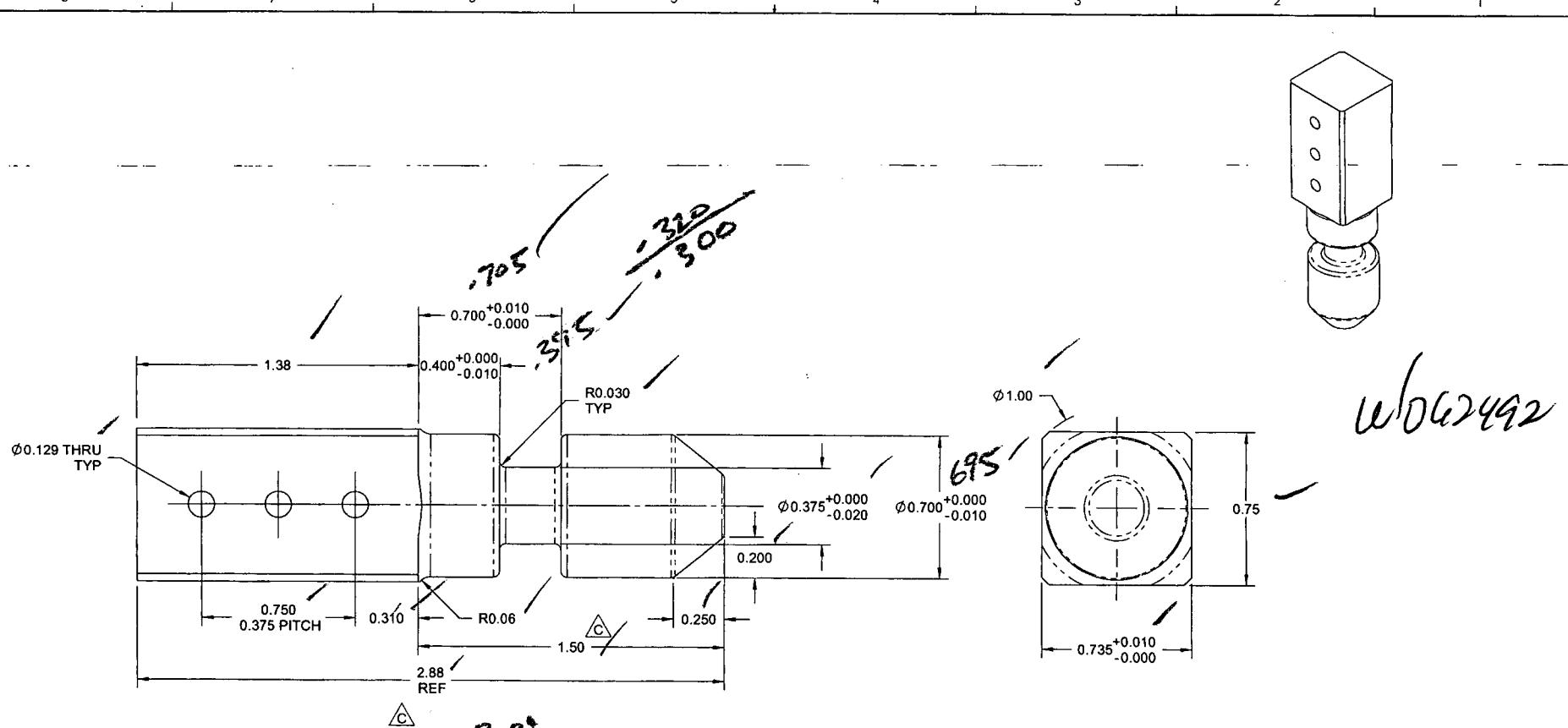
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NOTE: Date & initial all entries



D3909-5 EYEBOLT STUD

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR PER ASTM A582 OR ASTM A276
PER DART SPEC M303R OR M304R
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-5" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.34 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3909	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE: APPR.	<i>[Signature]</i>	FWD X-TUBE-LUG ASSY	NTS
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